

Date: Wednesday, 6/6/2007 3:04:17 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CONSOLE SIDE LH (206 HI-SLOPE)
Job Number	: 32819		
Estimate Number	: 11000		
P.O. Number	: <u>N/A</u>	Part Number	: D26021
This Issue	: 6/6/2007	Drawing Number	: D2602 REV A1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <u>N/A</u>	Drawing Revision	: A1
Previous Run	: 31332	Material	: <u>N/A</u>
Written By	:	Due Date	: 6/30/2007
Checked & Approved By	: <u>[Signature]</u>	Qty:	6 Um: Each
Comment	: Est. D 04.02.25 Reformat KJ/RF Note: Issue with part number D2602-2 Est Rev:E Now On Waterjet 07-03-22 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S040	2024-T3 .040 sheet
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Comment: Qty.: 1.4146 sf(s)/Unit Total : 8.4874 sf(s)
2024-T3 .040 sheet
Material: 2024-T3 (QQ-A-250/4) 0.040" thick
(M2024T3S.040) Batch M103032(8)

~~M100742(2)~~

SAD 07/06/15

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
1-Cut as per Dwg D2602
*****Same Cutting File for -1 & -2 *****
Dwg Rev: 41
Prog Rev: A1

2-Deburr if necessary

SAD 07/06/26

SAD 07/06/15

(P+O)

(6)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/06/15

6

4.0	QC8	SECOND CHECK
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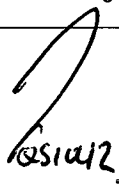
Comment: SECOND CHECK

SAD 07/06/15

(40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2602-1 PAR #: N/A Fault Category: Prod / 488.855 ^{med & small} NCR: Yes No DQA: Yes Date: 07/08/24
 QA: N/C Closed: Yes Date: 07.08.24

NCR: 32819		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/06/15	2.0	2 Scrap wrong material B# 100742M60615040		Scrap, destroy, replace Verify Verify the material prior to using.	SAD 07/06/15	Exp 07/06/18		Er 07/06/18

NOTE: Date & initial all entries

Date: Wednesday, 6/6/2007 3:04:17 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CONSOLE SIDE LH (206 HI-SLOPE)

Job Number: 32819

Part Number: D26021

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Deburr

Form as per Dwg D2602

SB 07/08/19 (6)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Er 02/08/20 (6)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M. 07/08/22

(6x)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

CL 07/08/22 (6)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/08/23 (6)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/08/24

Job Completion



07/08/24

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

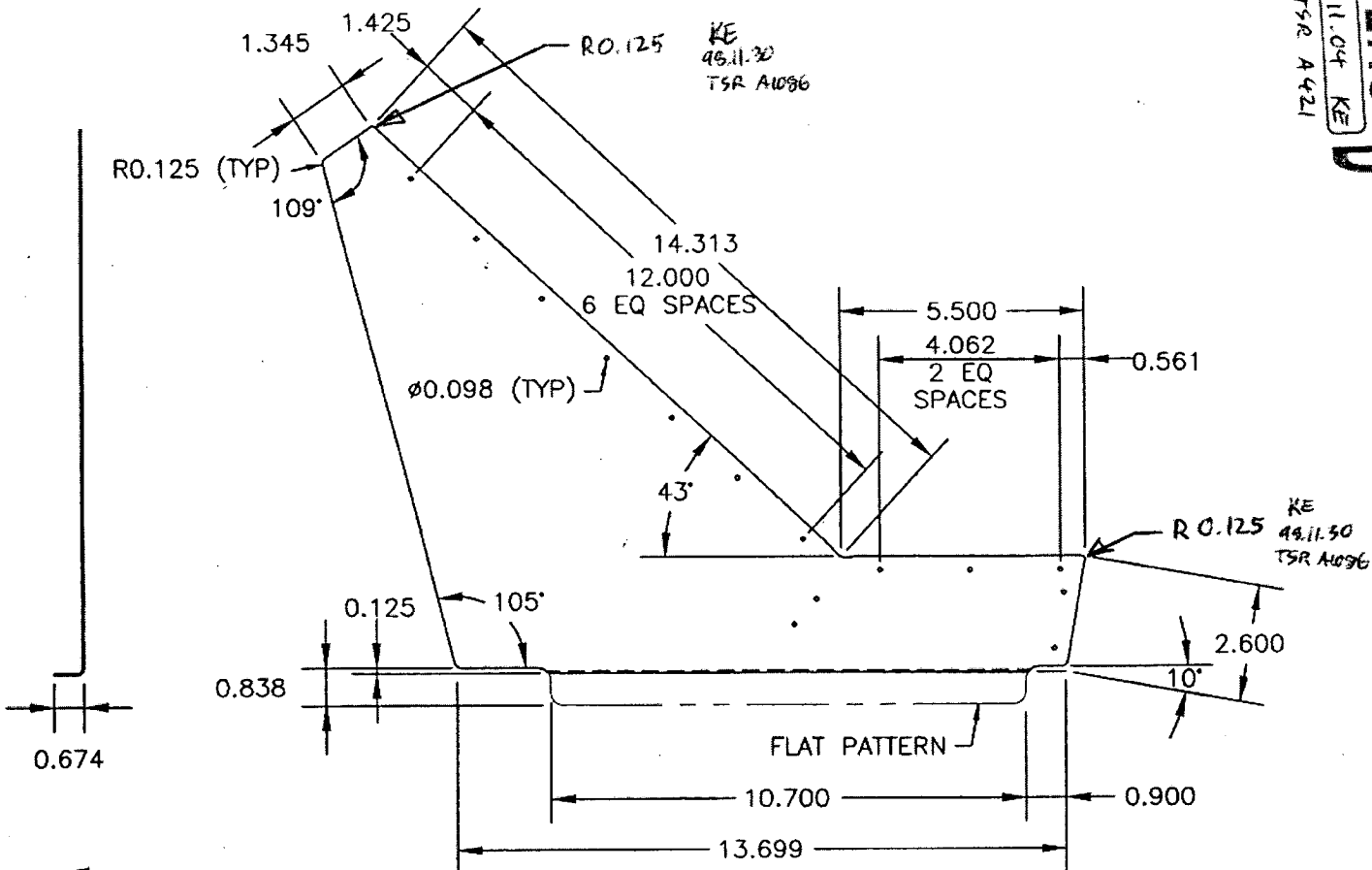
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART**RELEASED**
97.11.04 KE
TSR A421

DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA		REV. A
CHECKED KE	APPROVED B.W.	DRAWING NO. D2602	SHEET 1 OF 1	
DATE 97.10.22		TITLE CONSOLE SIDE	SCALE 1:4	
A	97.10.22	D2602 WAS D206-547-21/-22		
AI	02.06.04	ADD FINISH		



MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK
PROFILE CONTROLLED BY FOLIO H2602
BEND RADIUS 0.093
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 605 4.1
D2602-1 SHOWN
D2602-2 OPPOSITE



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 32819